

Date: Wednesday, 1/17/2007 7:33:47 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: R44 BEARPAW
Job Number	: 30311		
Estimate Number	: 12480		
P.O. Number	:	Part Number	: D35291
This Issue	: 1/17/2007 S.O. No. :	Drawing Number	: D3529 PRELIMINARY
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type MACHINED PARTS	Drawing Revision	: PREL
Previous Run	: 28031	Material	:
Written By	: <u>JLM 07-01-17</u>	Due Date	: 1/24/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: A New Issue 06-06-28 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 1.2796 sf(s)/Unit Total : 2.5593 sf(s)

Pick:

blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000)

Material: Black UHMW 1"(MUHMWB10)

Batch: M/01254

x 3 (parts) to 07/01/19

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

J.L 07/01/20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/01/20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 07/01/20

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A
prototype
CB

Date: Wednesday, 1/17/2007 7:33:47 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 30311

Part Number: D35291

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/08

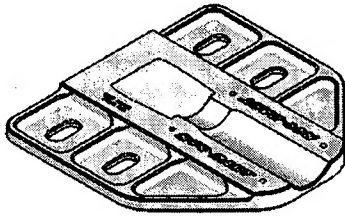
Job Completion



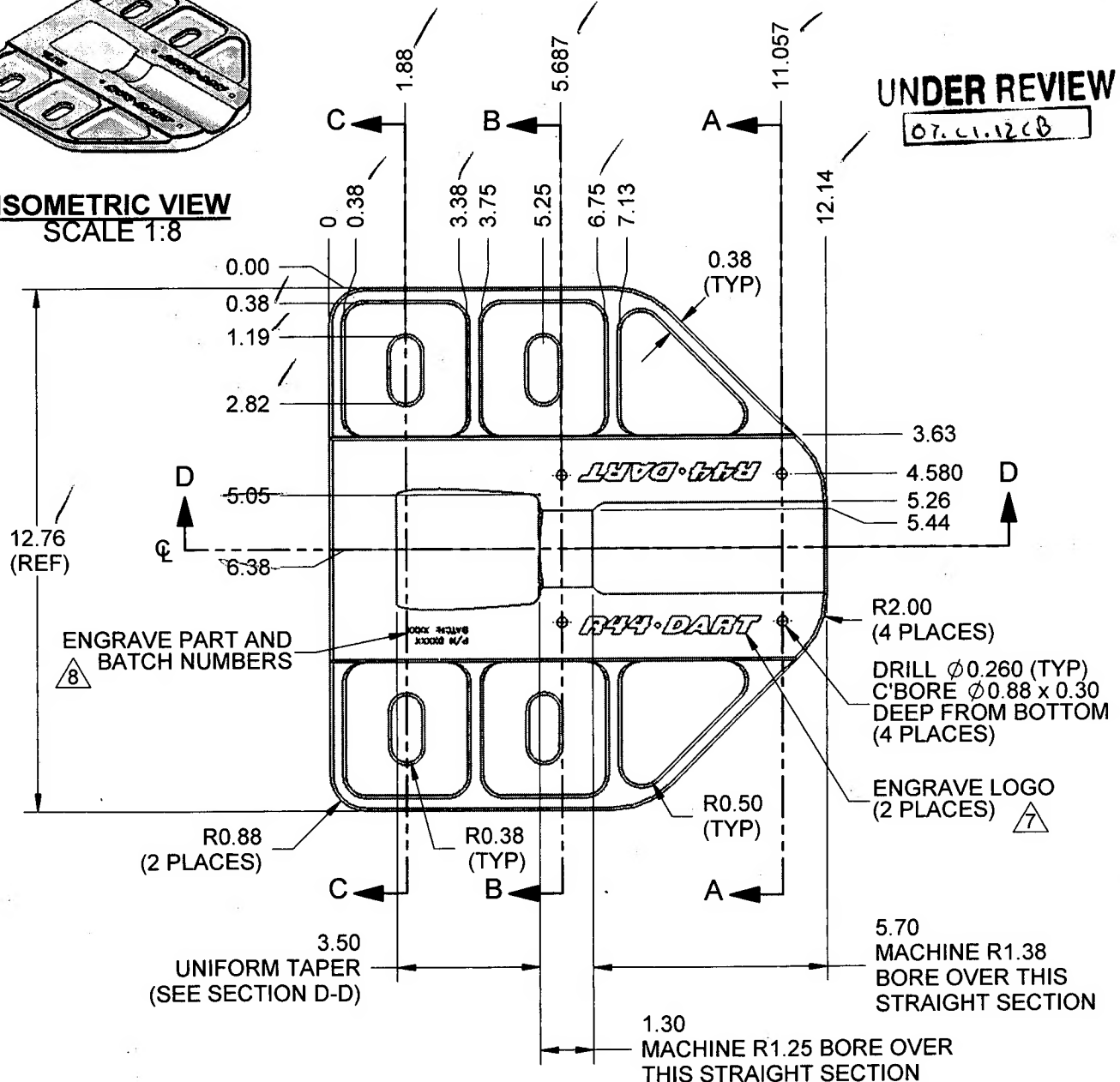
U 07-01-30

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04	TITLE R44 BEARPAW		SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

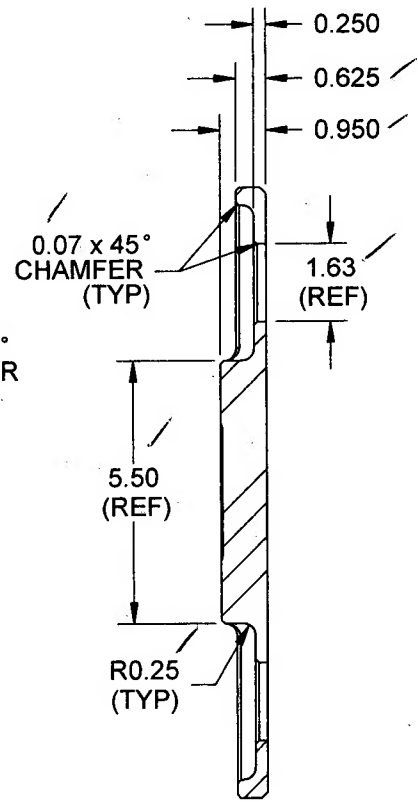
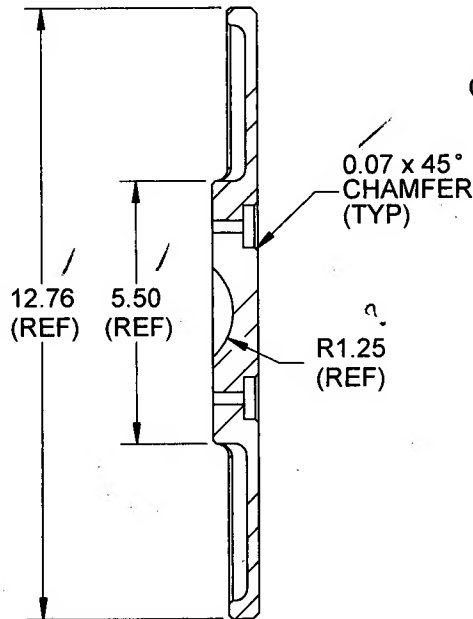
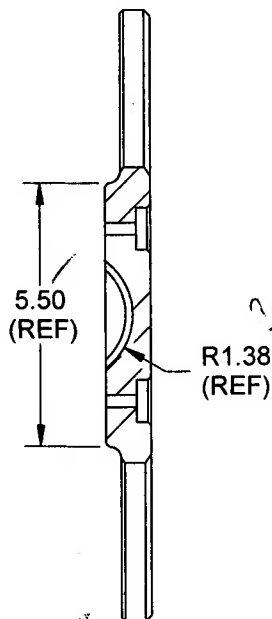
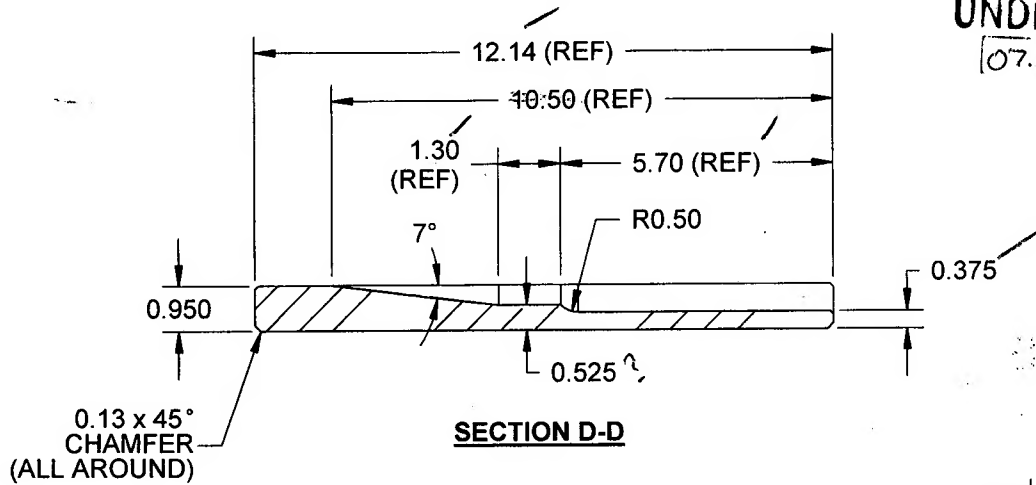
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PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

UNDER REVIEW
07.01.12 CB



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0501050

FROM
OUT

14 1573 21 TELAM 0701 211
050

DART AEROSPACE LTD		Work Order: 30311
Description: P44 bearing		Part Number: A3529-1
Inspection Dwg: A3529 , Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.14	± .030	12.149	✓			
1.30	"	1.315	✓			
5.70	"	5.695	✓			
.375	± .010	.376	✓			
.950	"	.953	✓			
.130X45°	± .030	.150	✓			
5.50	"	5.498	✓			
12.76	"	12.770	✓			
.07X45°	"	.072	✓			
1.630	"	1.620	✓			
.950	± .010	.952	✓			
.625	"	.628	✓			
.250	"	.252	✓			
.38	± .030	.379	✓			
1.88	"	1.879	✓			
5.687	± .010	5.688	✓			
11.057	"	11.058	✓			
1.190	± .030	1.190	✓			
2.82	"	2.820	✓			
3.38	"	3.374	✓			
6.75	"	6.748	✓			
3.75	"	3.751	✓			
7.13	"	7.133	✓			
5.25	"	5.252	✓			

Measured by: J.L.
Date: 07/01/20

Audited by: [Signature]
Date: 07/01/20

Prototype Approval: CB
Date: 07.03.08

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



G.E. POLYMERSHAPES

1250 OLD INNES RD, UNIT #519, OTTAWA, ONTARIO, K1B 5L3 / (613) 745-7043

OUR FAX # 745-4291

C E R T I F I C A T I O N O F C O N F O R M A N C E

SOLD TO: DART AEROSPACE

DATE: 06/08/06

YOUR PURCHASE ORDER: PO00001346.

LINE ITEM # 1

QUANTITY: 8 SHEETS.

DESCRIPTION: BLACK U.H.M.W. 1" X 48" X 120"

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: BLACK TIVAR 1000.

GE POLYMERSHAPES SHIPPER # : 072150.

SUPPLIER : POLY HI SOLIDUR

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

PAUL HAMILTON

OFFICE MANAGER.

Date: June 9/06
Supplier: GE Polymer Shapes

Batch No: 1101254
Dart P/O: 1346

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☒ No ☐ N/A ☐
Shipment Complete: Yes ☐ No ☐ N/A ☐
QC6 Inspection 526 06-06-14 N/A ☒
Work Order

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
UHMW 1" 10.5" x 13"		40	42	—	—	Excess material
1" UHMW 13.25" x 16"		20	21	—	—	"
1" UHMW 16" x 19.5"		20	21	—	—	"

Initials of receiver (if shipment OK) Level 12 AS

Production/Admin: 06/15/06
Date RCPI781
Received/Costing CS
Initial

Location

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: BLACK TIVAR 1000

GE POLYMERSHAPES SHIPPER #: 072150.
SUPPLIER: POLY HI SOLIDUR

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

PAUL HAMILTON

OFFICE MANAGER.

Paul Hamilton

PO Numbers
All Vendors
Part Number: MUHMB10
All OE Numbers
All Job Numbers
All Dates

PO Number	Vendor	Part Number	Job No	Ordered	BackOrder	Unit Price	Extended Ord	Date Del	Date
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Notes: 8 SHEETS 4' X 10' X 1" BLACK UHMW
UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
MANUFACTURER: POLY HI SOLDUR
1" GUARANTEED - TOLERANCE +0.030/NO MINUS
PACKAGING: MATERIAL MUST BE PROTECTED FROM
STRAPPING WITH CARDBOARD. SCRATCHES WILL NOT
BE ACCEPTED.

CUT SIZES AS FOLLOWS:

20 - 19.50 X 48
20 - 16.00 X 19.50
30 - 19.50 X 24.00

2008821 CADI MUHMB10

320.00 0.00 19.1250/sf 6120.00 10-14-05 10-27-05

Notes: NOTE: 8 SHEETS 4' X 10' X 1" BLACK UHMW
→ UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
MANUFACTURER: POLY HI SOLDUR
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CUT SIZES AS FOLLOWS:

20 - 19.50 X 48.00
10 - 13.25 X 16.00
40 - 19.50 X 24.00
10 - 16.00 X 19.50

40x 10.5 x 13

20x 13.25 x 16

Total PO Values: Original Orders : \$ 162019.77 Back Orders : \$ 0.00

40x 19.50 x 24

20x 16 x 19.50

Dart Aerospace Ltd.

Hawkesbury, C